



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE703A95-0505-00-1
Job Sheet 173883



Part No: RBE703A95-0505-00-1

Job Qty: 6 ea

Part Name: Quill



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0505-00 Rev 9 IPP Rev A 18.01.15 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/6/18	0.00	0.00	Start Up Machining-2		SL 18-6-7
110	CNC Lathe	6 pcs		4/7/18	0.00	6.00	MORI SL-154		SL
120	QC	6 pcs		4/7/18	0.00	0.00	QC2 Machining-4		5-25
122	Mill Conv	6 pcs		4/9/18	0.00	3.00	Mill Conv 1		
124	QC	6 pcs		4/9/18	0.00	0.00	QC2 Machining-2		18/6/20
130	QC	6 pcs		4/9/18	0.00	0.00	QC8 Machining-4		B.A 18-06-22
150	Outsource	6 pcs		4/14/18			ATC001-VG ALTECH 5		CT 18-6-25
160	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging2		Ind. 18-07-02
170	QC	6 pcs		4/14/18	0.00	0.00	QC6		38
180	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging3-1		SP18-07-3
190	QC21-SA	6 Ea		4/14/18	0.00	0.00	QC21		DAG 9-89 JUL 03 2018

Part Op 110 - 1-Machine as per DWG. FB789 FOLIO REV: AA DWG REV: 9 2-Debur 3-Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.
122 - 1-Machine flats as per DWG. 2-Debur
130 - ALTECH
150 - Issue P/O to ATG : PO 040319 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0505-00-1 Rev. 9 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.125	6061 Round Bar 1.125	1.6200 ft (.27 ea)	90-Start up Operation	SC68498

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.125	2 = 3.15	6 = 15	0

Specifications

could not be found.

Plex 3/8/18 7:57 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S078893



Part: RBE703A95-0505-00-1

Job No: 173883

Serial No/Batch: S078893

Revision: 9

Inspector:

Exp Date: 06/07/2018

Instructions:

Date: 06/07/18

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WITHOUT NOTICE

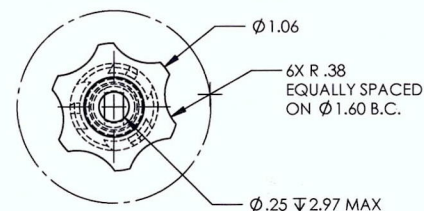
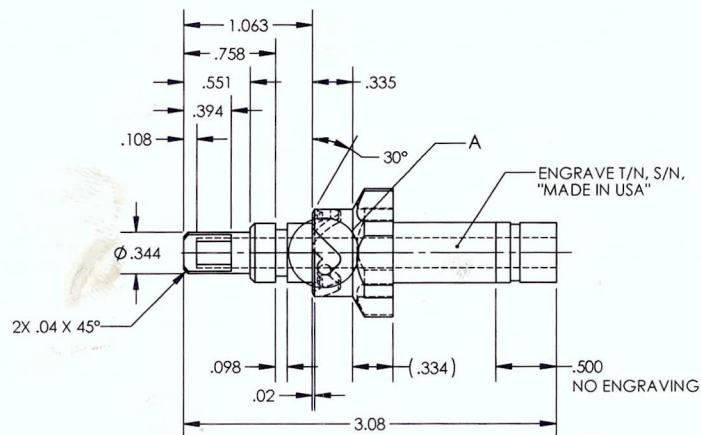
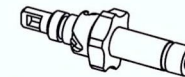
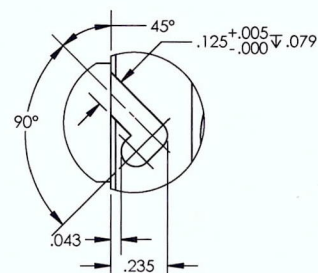
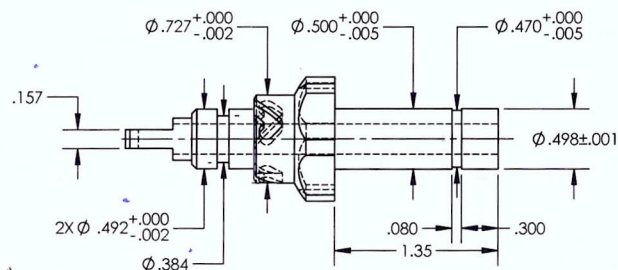
WORK ORDER

NO. 113883

20180501

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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL
1		CHANGED O-RING SIZE FROM Ø14.4mm OD x 2.4mm CROSS SECTION. ALSO ADDED NOTES. CHD SLOTS FROM 90° Ø.131 AND ID FROM .230	5/28/2009	WP
1A		DELETED 49° REF. DIM. FOR -1 PER G.E.	12/14/2010	RJC
2		CHD ENGAGEMENT SLOT ANGLE FROM 60° TO 90° PER G.E.	3/7/2011	RJC
3		CHD STEM LENGTH FROM .800 TO 1.35, DELETED BARB, ADDED GROOVE.	7/30/2012	JAG
4		CHD 6X R.155 & 8X .121 TO 6X R.375 & 6X .106	4/17/2013	CFS
5		-1 CHD DIM WAS Ø.125 ± .005/- .0005 ± .0005. CHD DIM WAS 6X .106 IS 6X .111. CHD DIM WAS 6X R.375 IS 6X R.38.	6/19/2013	BIM
7B		-1 CHD DIMS WAS 2X .039 X 45° IS 2X .40 X 45°. WAS .020 IS .02. WAS 2X 30° IS 30°. WAS 6X .11 IS 6X R.38 EQUALLY SPACED ON Ø1.60 B.C. WAS Ø.250 IS Ø.25 THRU 2.97 MAX. ADDED NOTES WAS ENGRAVE T/N IS ENGRAVE T/N, S/N, "MADE IN USA". WAS .500 IS .500 NO ENGRAVING. DELETED DIMS .095, .244.	2/5/2014	DPD
9	16-0257	-1 CHD DIM WAS Ø.25 THRU 2.97 MAX IS Ø.25 ± 2.97 MAX.	12/5/2016	SM



Ⓢ
QUILL

DART AEROSPACE	
TITLE TGB DRAIN TUBE	
DWG NO. RBE703A95-0505-00-1	REV 9
MAT'L 6061 HEAT TREAT FINISH RED ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II DRAWN BY: PERRITT CHECKED: CLOUGH GRPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 9° .X ± .1 SURFACES ± 125/ .015 X 45° OR .015R 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EUROCOPTER AS-350	
SCALE 1:1	DATE 7/30/2012
SHEET 2 OF 2	

DART AEROSPACE LTD		Work Order:	173883
Description: Quill		Part Number:	RBE703A95-0505-00-1
Inspection Dwg: RBE703A95-0505-00-1		Rev: 9	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.157	±.005	0.158	✓		Vernier CMC-19	
.492	+0 -.002	.491	✓		mic	SL-4
.384	±.005	.384	✓		VERN	
1.35	±.01	1.349	✓			
.080	±.005	.079	✓			
.300	±.005	.300	✓			
.498	±.001	.4988	✓		mic	
.470	±.005	.468	✓			
.500	+0 -.005	.4988	✓			
.727	+0 -.002	.726	✓		mic	
1.063	±.005	1.064	✓		VERN	
.758	±.005	.758	✓			
.551	±.005	.552	✓			
.394	±.005	0.392"	✓		Vernier CMC-19	
.108	±.005	0.113"	✓		"	
.344	±.005	.344	✓			
.04X45°	±.01 ±.5°	.04X45°	✓			
.098	±.005	.098	✓			
3.08	±.01	3.079	✓			
.334	±.005	.334	✓			
.335	±.005	.335	✓			
.043	±.005	.045	✓			
.235	±.005	.235	✓			
.125	±.005-0	.125	✓			
±.079	±.005	.077	✓			
1.06	±.01	1.061	✓			
0.25	±.01	.251	✓			
±2.97	+0 -.01	2.965	✓			

Measured by: SL / W 18/6/22	Checked by: B.A	QC Inspector:
Date: 18-6-7	Date: 18-06-22	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040319**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040319
PO Date: 6/26/18
Due Date: 6/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178046	647.8511	Insert -Issue P/O to Groupe Altech: P/O _____ -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	6/29/18	4 pcs	0 pcs	4 pcs	\$1.41162059/pcs	\$5.65
Line Item Note ** rush - need back asap **										
2	175623	C3-8-5	Solenoid Cover -Issue P/O to GROUPE ALTECH: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/29/18	20 pcs	0 pcs	20 pcs	\$3.08647059/pcs	\$61.73
3	178948	TM3039G001	Draining Tool -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/29/18	10 pcs	0 pcs	10 pcs	\$2.82330059/pcs	\$28.23

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	173883	RBE703A95-0505-00-1	Quill -Issue P/O to Groupe Altech: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0505-00-1 Rev. 9 -Certificate of Conformity is required	Firmed	6/29/18	10 pcs	0 pcs	10 pcs	\$10.8055606/pcs	\$108.06
5	179351	RBT18649-13	Main Rotor Hub Work Aid Item #13 -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/29/18	11 pcs	0 pcs	11 pcs	\$3.66647059/pcs	\$40.33
6	179164	646.3910	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	6/29/18	30 pcs	0 pcs	30 pcs	\$4.16/pcs	\$124.80
7	179165	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	6/29/18	20 pcs	0 pcs	20 pcs	\$4.16/pcs	\$83.20
8	177368	SK145-0115-20	Clamp Bar ISSUE P/O: _____ PASSIVATE AS PER DWG ACCORDANCE WITH ASTM A967 C OF C IS REQUIRED	Firmed	6/29/18	22 pcs	0 pcs	22 pcs	\$1.80647059/pcs	\$39.74
9	178824	RBW6505G00831-3G-7	Swivel Plate Weldment -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; A36 -Certificate of Conformity is required	Firmed	6/29/18	1 pcs	0 pcs	1 pcs	\$104.896471/pcs	\$104.90
Line Item Note ** Rush - need back by Friday 6/29 **										
10	177859	RBW6505G00831-3G-1	Leg Assembly Weldment -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; A36 -Certificate of Conformity is required	Firmed	6/29/18	1 pcs	0 pcs	1 pcs	\$104.896471/pcs	\$104.90
Line Item Note ** Rush - need back by Friday 6/29 **										

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Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
11	178044	647.8510	Insert ISSUE PO: _____ SUPPLIER: GROUPE ALTECH -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	6/29/18	40 pcs	0 pcs	40 pcs	\$1.41162059/pcs	\$56.46
Line Item Note ** need back asap **									Grand Total:	\$758.00

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CT.

Plex 6/27/18 2:34 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(010576-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010576 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
29-Jun-2018		Aman		040319				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	C3-8-5 Rev.	C3-8-5 01-ANO-BLACK [ANODIZE BLACK] PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	20	20	0	0	0
3	TM3039G001 Rev.	TM3039G001 01-ANO-BLACK [ANODIZE BLACK] PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
4	RBE703A95-0505-00-1 Rev.	RBE703A95-0505-00-1 01-ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
5	RBT18649-13 Rev.	RBT18649-13 01-ANO-BLACK [ANODIZE BLACK] PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	11	11	0	0	0
6	646.3910 SHIM Rev.	646.3910 SHIM CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2,CL2	CADMIUM CH	30	30	0	0	0
7	646.3912 Rev.	646.3912 CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2	CADMIUM CH	20	20	0	0	0
9	RBW6505G00831-3G-7 Rev.	SWIVEL PLATE WELDMENT 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours	ZINC CH	1	1	0	0	0
10	RBW6505G00831-3G-1 Rev.	LEG ASSEMBLY WELDMENT 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	1	1	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.